

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027931**Date Inspected:** 10-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Scott Kortum**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS project**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector performed Ultrasonic Testing (UT) of Electro Slag Welding (ESW) joints in the Self Anchored Suspension (SAS) Tower, Shear Plates, for verification purposes at the locations listed below:

S-045 ("G"): QC Inspector Scott Kortum informed this QA Inspector he had completed UT at this weld joint from Face-B and from Y-9000 to Y9850. This QA Inspector performed UT verification of this area using a 70 degree shearwave transducer and observed both parallel and transverse recordable UT indications. A total of 7 areas were identified as having recordable UT indications; 2 areas contained longitudinal indications and 5 areas contained transverse indications. See Ultrasonic Testing Report (TL-6027) this date for further details. QC Inspector Scott Kortum informed this QA Inspector had started scanning from Y-3100 and got as far as Y-4000 this afternoon and would be ready for QA verifications tomorrow morning.

E-045 ("F"): This QA Inspector performed UT using a 70 degree shearwave transducer from Face A and observed both parallel and transverse UT indications in the weld from Y-7500 to 9850. A total of 7 areas were identified as having recordable UT indications; 3 areas contained longitudinal indications and 4 areas contained transverse indications. See Ultrasonic Testing Report (TL-6027) this date for further details.

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This QA Inspector did not observe welding being performed this date.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during the shift. Except as described above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
